

5/44

DART AEROSPACE LTD	Work Order:	24630
Description: Stud	Part Number:	D3028-1
Dwg: D3028 Rev. A	Qty:	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	RF	05.10.21	20
2	MC	Turn blank per Dwg D3028 and FA263 Material: AISI 4130N Bar per MIL-S-6758 or AMS 6348/ 6370/ 6528 Ø0.750" (M4130N-R0.750) Batch <u>M18767</u> Threads per MIL-S-7742	J.G	05/11/14	20
3	VMC MV	Cut groove as per Dwg D3028 and FA263	En	05/11/18	20
4	VMC MV	Deburr and Tumble for 5 min. max. a short time to prevent damage to threads 04.06.21 RF	En	05/11/18	20
5	QC2	Inspect parts as they come off the CNC machine	En	05/11/18	20
6	QC8	Second check	mf	05/11/18	20
7	PG	Issue P/O <u>2008929</u> Finish : Cadmium plate per QQ-P-416F Class 1, Type II Material release note is required.	RF	05/11/24	20
8	RG	Receive and Inspect for transit damage Ensure that material release note is attached	CL	05/11/30	20
9	ST	Identify and Stock <u>Loc 394</u>	/	05/11/30	20
10	AC	Cost / part	Sue	05-12-07	20
11	DC	Close W/O Inspect Level 21	RF	05/12/07	20



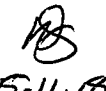

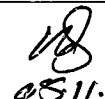
Rev	Date	Change	Revised By	Approved
A	01.05.30	New issue	EC	
B	02.09.10	Made on Cobra	KJ RF	

RELEASED
02/09/12 RF

RF
02.11.04

Pho

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/11/18	#3	one part moved in collect. groove is all.		Acceptable		 05-11-18	 05/11/18	 05/11/18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/12/07

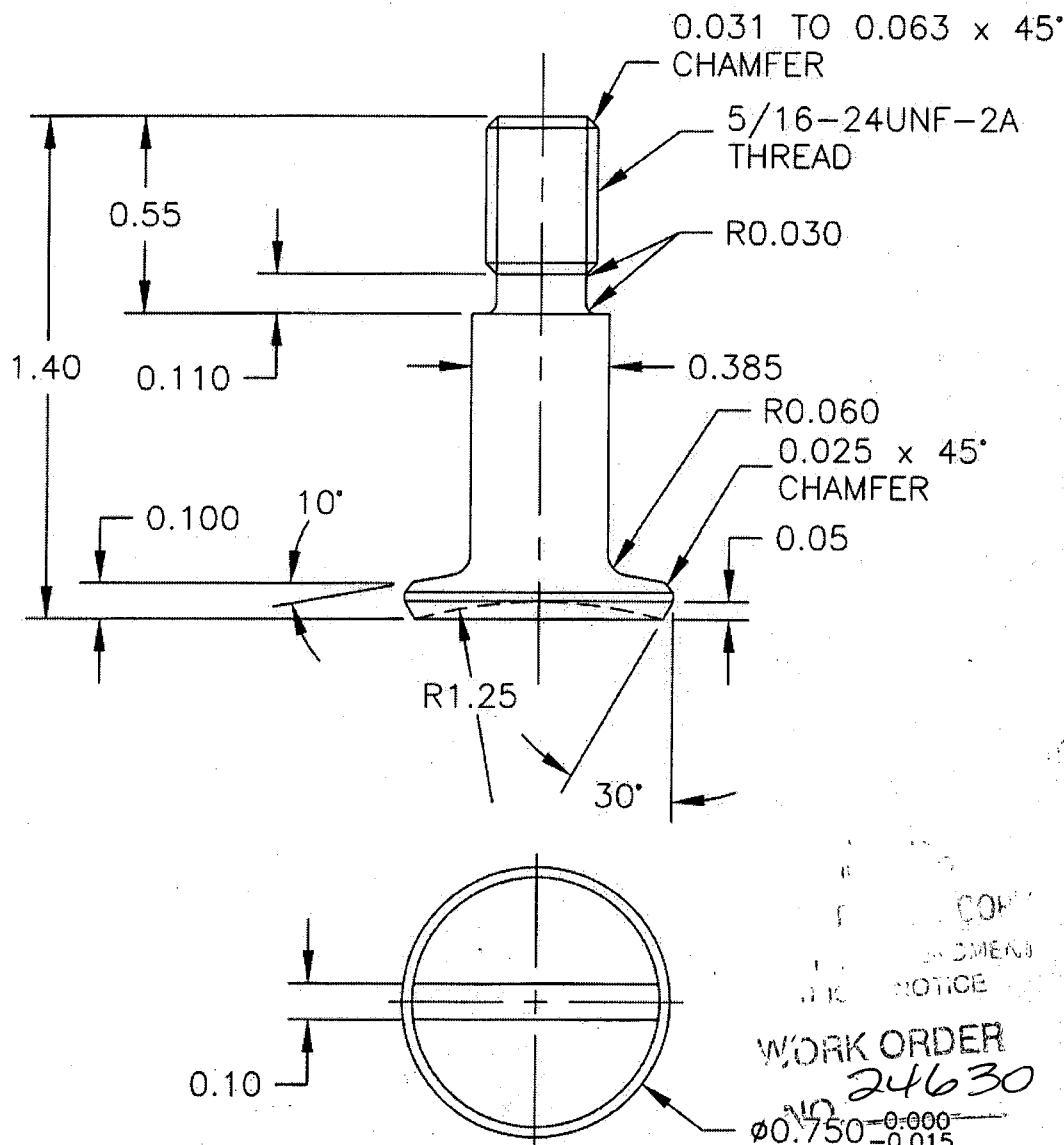
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3028	REV. A SHEET 1 OF 1
DATE 01.05.18	TITLE STUD		SCALE 2:1
A	01.05.18	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D3028-1:

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES P/N B83602-1
- 2) MATERIAL: AISI 4130N BAR PER MIL-S-6758 OR AMS 6348/6370/6528
- 3) THREADS PER MIL-S-7742
- 4) FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.30

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 20, 2005
04:09 pm

Work Order No : 0024630
Project Name : D3028-1
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D3028-1
Description : Stud
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 10-20-05
Est Finish Date : 11-04-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24630
Description:		Part Number: D3028-1
Inspection Dwg: D3028 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.40	± 0.030	1.405	✓			
0.55	± 0.030	0.555	✓			
0.110	± 0.010	0.101	✓			
0.100	± 0.010	0.108	✓			
10°	$\pm 1/2^\circ$	10°	✓			
0.071 to 0.063 x 45°	± 0.010	0.045 x 45°	✓			
R0.030	± 0.010	R0.030	✓			
0.385	± 0.010	0.386	✓			
R0.060	± 0.010	R0.060	✓			
0.025 x 45°	± 0.010	0.025 x 45°	✓			
0.05	± 0.030	0.043	-			
R1.25	± 0.010	1.25	-			
30°	$\pm 1/2^\circ$	30°	✓			
0.112	± 0.030	0.098				
0.750	± 0.000	0.744	✓			
(5116-24 UNF 2A) MOW = .332	± 0.015 ± 0.001	0.333	✓			

Measured by: J.G	Audited by: ml	Prototype Approval: N/A
Date: 05/11/14	Date: 05/11/14	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

MANCO DOMPLEX

8895 Crescent 3
Anjou (Québec) H1J 1B6
Tél.: (514) 355-7887
Fax: (514) 355-8750

CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE

4031

613 632 4443

Dart Aerospace
Client / Customer

D.302 81
de la pièce / part

2008929
Votre # de commande / Your purchase order #

97326
Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector <u>Beneut</u>	Date, équipe / Date, shift <u>Nov 29, 2005</u>
Placage / Plating <u>QAP-416-C</u>	
Quantité totale / Total quantity <u>20</u>	Quantité inspectée / Inspected quantity <u>20</u>
Adhésion / Adhesion <u>Good</u>	
Épaisseur / Thickness L.C.D.	H.C.D. Moy / aver. <u>0.0005</u>
Coussures, laches / Leach, spots <u>NO</u>	Rugosité / Roughness <u>NO</u>
Quantité approuvée / Approved quantity <u>20</u>	Quantité rejetée / Rejected quantity

Commentaires / Comments

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications

Signé au nom de
Signed on behalf of

**MANCO
DOMPLEX**